

Work Order ID 82670

82670

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Item ID: D2066, Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Arm
 Start Date: 04/04/2012 Start Qty: 4.00 ***4*** Cust Item ID:
 Required Date: 18/04/2012 Req'd Qty: 4.00 ***4*** Customer:
 Reference:

Approvals: Process Plan: MLJ Date: 12/04/04 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2066	Rev C								

100 0.00
100 Small Fab
 Small Fab Memo 0.00
 Small Fab 1-Punch 1/2" OD x .049" Wall 304/316 SS Seamless Tube
 (Ref QSI 017 4.1.1.2) as per Dwg D2066 (per D2727)
 Use punch Jig DT8012
 2-Slide on parts per Dwg and W/O for D2676-043
 3-Punch other end to length (28.62") as per Dwg D2066
 4-Bend per Dwg D2066
 5-Drill using DT9034

110 0.00
110 QC5- Inspect part completeness to step on W/O
 QC Memo 0.00
 Quality Control

4 ~~0~~ FF
 12-04-12

(x4)

5/12/04/18

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	Identify as per dwg & Stock Location: _____	0.00							
120									
Packaging	Memo	0.00							
Packaging									
130	QC21- Final Inspection - Work Order Release	0.00							
130									
QC	Memo	0.00							
Quality Control									

Handwritten signature and date: 12/4/23

Handwritten signature and date: 12/4/23

Handwritten text: Bl 1204-23

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Picklist Print

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Page 1

Work Order ID: 82670

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Parent Item: D2066

D2066

Parent Item Name: Arm

Start Date: 04/04/2012

Required Date: 18/04/2012

Start Qty: 4.00

Required Qty: 4.00

Comments:

IPP D 02.03.18 Added pick list NG

IPP E 07.10.03 removed p/c EC verified by: DD

IPP Rev:F 08-07-24 revC as per dwg (ecn 08-504) DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN960JD10	NAS1149D0363J	Purchased	No			100	Each	0.0000	4	16			
AN960.ID10					121243				**	16		FF 12-04-10	
Washer													
D2052		Manufactured	No			100	Each	20.0000	2	8			
D2052									**			FF 12-04-10	
Mounting Bracket													
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				GA		20							
					73052	3							
					77088	17							
D2054		Manufactured	No			100	Each	42.0000	2	8			
D2054									**			FF 12-04-10	
Bushing													
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				GA		42							
					67784	12							
					79836	30							
D2055		Manufactured	No			100	Each	25.0000	1	4			
D2055									**			FF 12-04-10	
Clamp													
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				GA		25							
					71890	4							
					77110	21							

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Parent Item: D2066

D2066

Parent Item Name: Arm

Start Date: 04/04/2012

Required Date: 18/04/2012

Start Qty: 4.00

Required Qty: 4.00

D2056

Manufactured No

100

Each

17.0000

1

4

D2056

Bell Crank

**

FF 12-04-10

Location

Loc Qty

Loc Code

GA

17

71102

2

71889

15

4

MS21042L3

Purchased

No

100

Each

2,342.000

2

8

MS21042L3

Nut

**

FF 12-04-10

Location

Loc Qty

Loc Code

ST300

2342

117441

16

117885

32

118451

5

118927

3

119017

2060

8

119075

166

121162

60

MS27039-1-18

Purchased

No

100

Each

44.0000

2

8

MS27039-1-18

Screw

**

FF 12-04-10

Location

Loc Qty

Loc Code

ST291

44

115589

19

120308

25

8

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Shop Packet Print

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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Parent Item: D2066

D2066

Parent Item Name: Arm

Start Date: 04/04/2012

Required Date: 18/04/2012

Start Qty: 4.00

Required Qty: 4.00

M304TR0.500W.049

Purchased

No

120

f

279.8131

2.386

10.04632

M304TR0 500W 049

**

FF 12-04-18

304 RD Tube .500 x .049W

Location

Loc Qty

Loc Code

MAT017

279.813058

111814

2.23

115010

109.254058

117598

3.97

119087

7.359

120633

157

10.04632

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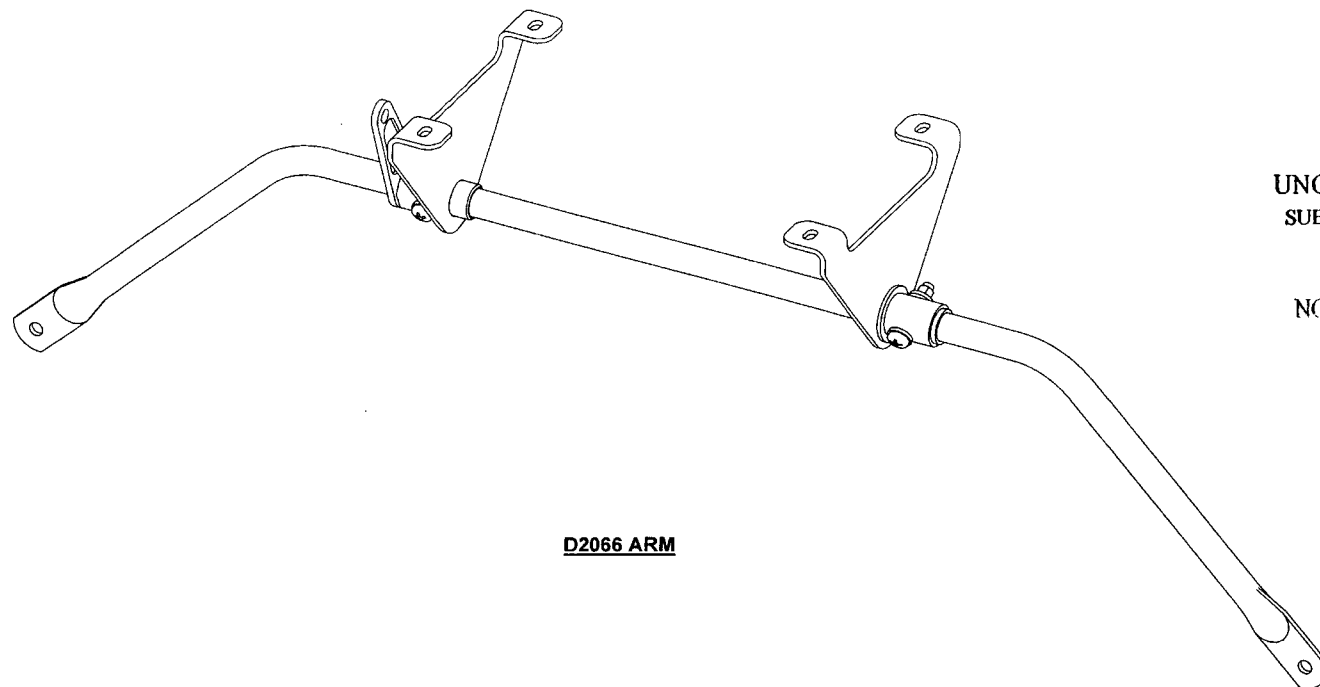
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D2066 ARM

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

NO. 82670 MLJ
12/04/04

RELEASED
08-07-25-104

- NOTES:**
1) MATERIAL: N/A
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: IDENTIFY WITH DART P/N "D2066" USING FINE POINT PERMANENT INK MARKER
7) WEIGHT: 0.85 lbs

C	REDRAWN IN SOLIDWORKS; ADD D2066-1F CUT LENGTH DETAIL (ZN B4-2) AND D2066-1 BENDING DETAIL (ZN C4-2) FOR D2066; Ø0.500 X 0.049 WALL WAS Ø0.500 X 0.035 WALL (ZN A5-2); REASON: Ø0.500 X 0.035 WALL TUBING USED ON D2010 IS CRACKING DURING SERVICE	PH	08.06.12
B	RE-DESIGNED	BW	96.02.06
A	NEW ISSUE	BW	92.03.12
REV.	DESCRIPTION	BY	DATE
DESIGN	BW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	<i>[Signature]</i>		
CHECKED	<i>[Signature]</i>	DRAWING NO. D2066	REV. C
MFG. APPR.	<i>[Signature]</i>	SHEET 1 OF 2	
APPROVED	<i>[Signature]</i>	TITLE ARM	SCALE
DE APPR.	<i>[Signature]</i>	NTS	
DATE	08.06.12	<small>COPYRIGHT © 1996 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>	

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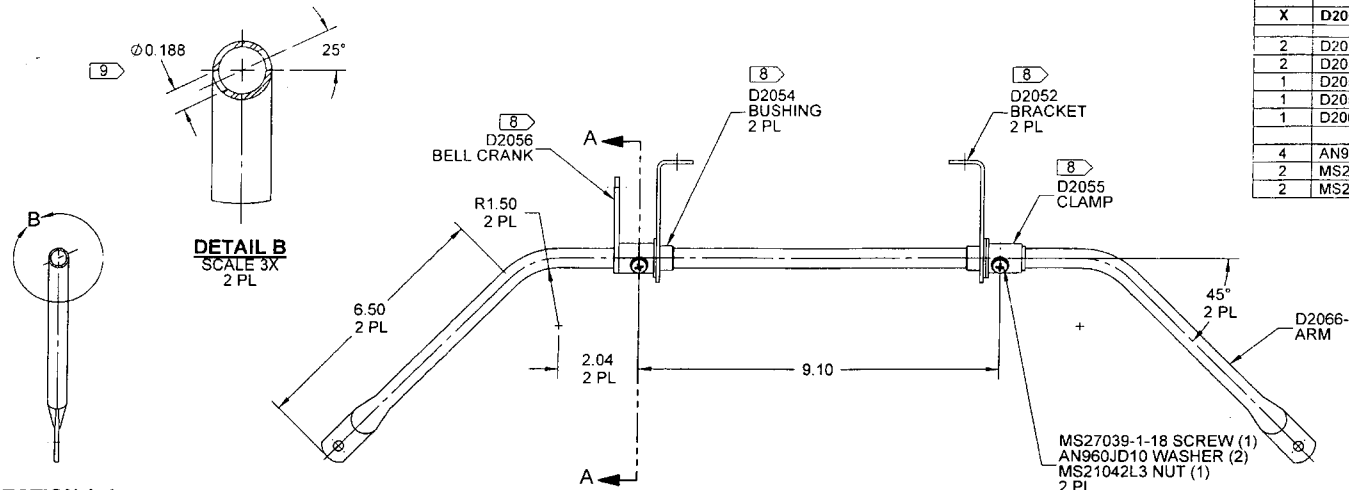
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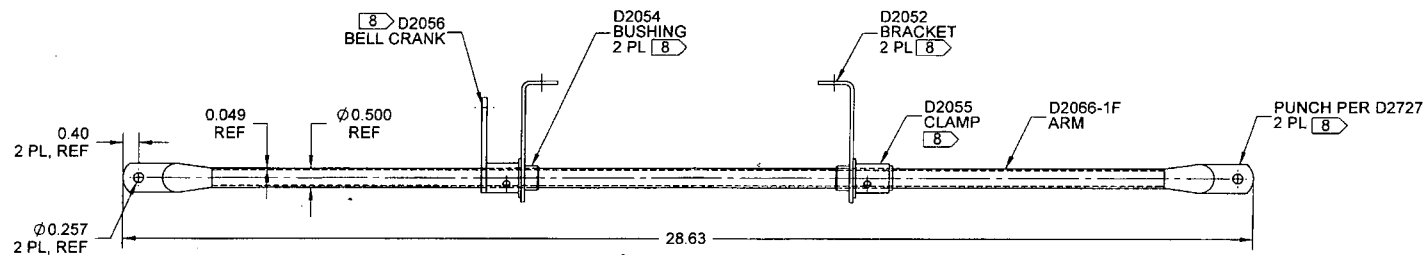
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82670



RELEASED
08-07-13

NOTES:

- 1) MATERIAL: D2066-1F: AISI 304/316 SS SEAMLESS ROUND TUBING, $\phi 0.500 \times 0.049$ WALL (REF DART SPEC M304TR0.500W.049)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: D2066-1 = 0.62 lbs (SEE SHEET 1 FOR ASSEMBLY WEIGHT)
- 8) BEFORE BENDING: ADD D2052 BRACKETS, D2054 BUSHINGS, D2055 CLAMP AND D2056 BELL CRANK TO D2066-1 ARM
AFTER FIRST END OF D2066-1 IS PUNCHED AND BEFORE SECOND END OF D2066-1 IS PUNCHED
- 9) DRILL $\phi 0.188$ AFTER BENDING

DESIGN	BW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AL		
CHECKED	JS	DRAWING NO. D2066	REV. C
MFG. APPR.	JS	SHEET 2 OF 2	
APPROVED	JS	TITLE ARM	SCALE
DE APPR.	JS	NTS	
DATE	08.06.12	COPYRIGHT © 1996 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

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